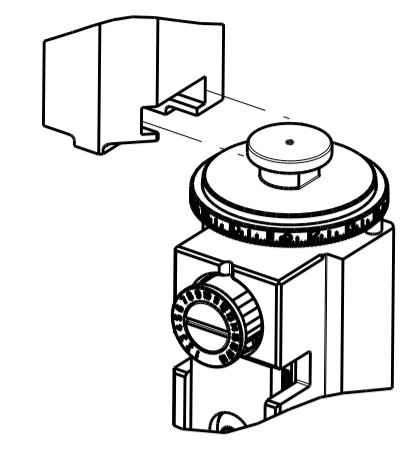


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151694-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151694-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151694-1	C	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151694-2	D	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151694-7	A	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 2,5MM SYSTEM CONTACT SOCKET			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.20-5.80 mm [.205-.228 IN]	Ø1.00-1.60 mm [.039-.063 IN]		
TERMINAL APPLICATION SPECIFICATION	114-18031-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928972-2	928972-3	928972-4	928972-5
928973-2	928973-3	928973-4	2-928973-2
2-928973-3	928974-2	928974-4	928974-5
928975-2	928975-3	928975-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11 +/- 0.03 [.044 +/- .001]	6.5
0.25mm2	1.07 +/- 0.03 [.042 +/- .001]	7.1
0.20mm2	1.05 +/- 0.03 [.041 +/- .001]	7.4

- 1. RECOMMENDED SPARE PARTS
- 2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5. INSULATION CRIMP HEIGHT SPECIFIED IN 114-18031-1 IS ONLY PERTINENT IF APPLICATION IS SPECIFIC FOR BMW. ALL OTHER APPLICATIONS SHOULD BE SET TO OPTIMUM INSULATION CRIMP HEIGHT RELATIVE TO INSULATION DIAMETER BEING USED.
- 6. CUT TO LENGTH AT ASSEMBLY.
- 7. TERMINAL LUBRICANT IS RECOMMENDED.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPV
		A	RELEASED	26OCT2012	KH SX
		B	ECR-17-011566	09AUG2017	FZ KZ
		C	ECR-18-007838	23MAY2018	VLA JDG
		D	ECR-19-010982	12JUL2019	MZ YY

-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
7	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1338685-1	PAWL, FEED	56
6	-	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	2	2	1	1-1333202-6	ANVIL, COMBINATION	8
-	1	1	1	1	6-240641-8	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	3-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	2	2	1	3-456403-7	CRIMPER, WIRE PREMIUM	1

ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

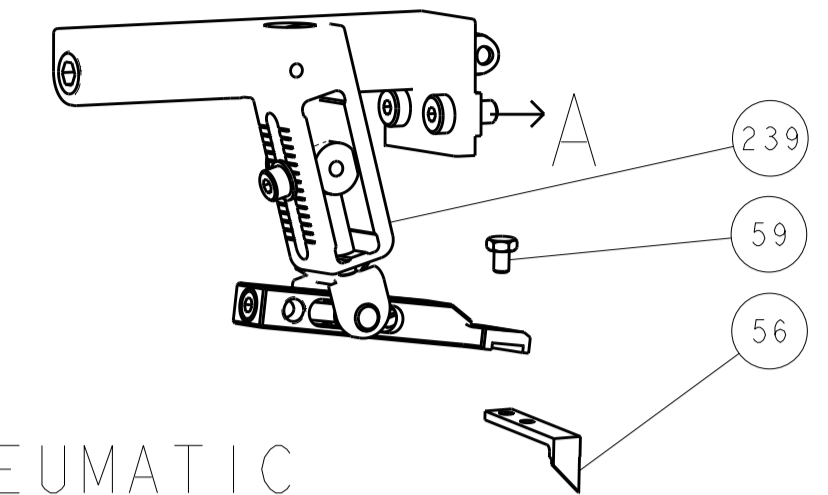
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	

DATE	31 JUL 2012	CHK	H. HUANG	APPV	S. XI
DATE	31 JUL 2012	CHK	S. XI	APPV	S. XI
DATE	31 JUL 2012	CHK	S. XI	APPV	S. XI

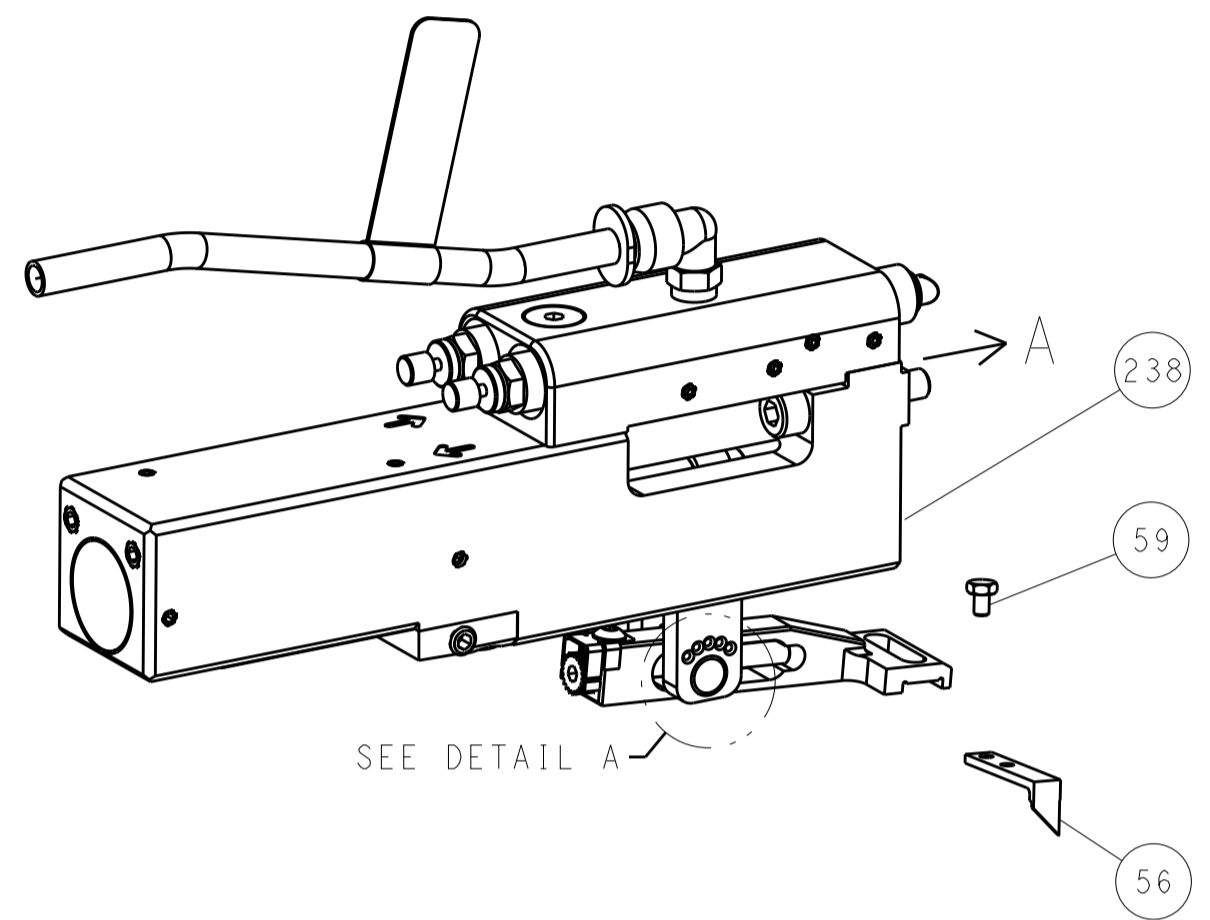
NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	2151694	
Customer Accessible Production Drawing		SCALE	1:2
SHEET		1	OF 4
REV		D	

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

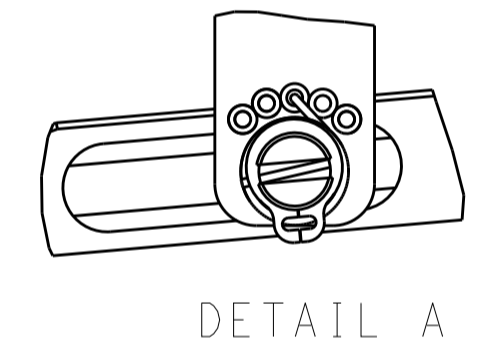
# FEED TYPE MECHANICAL



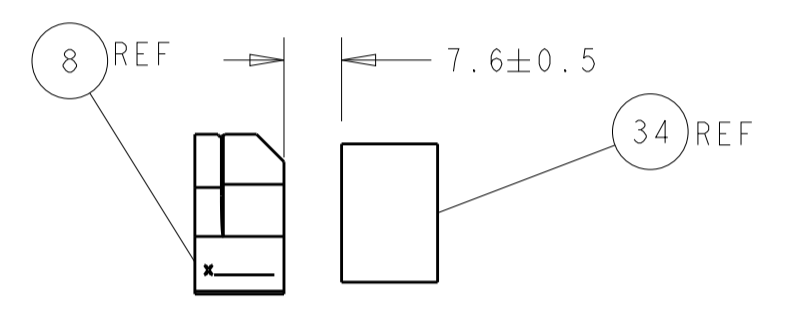
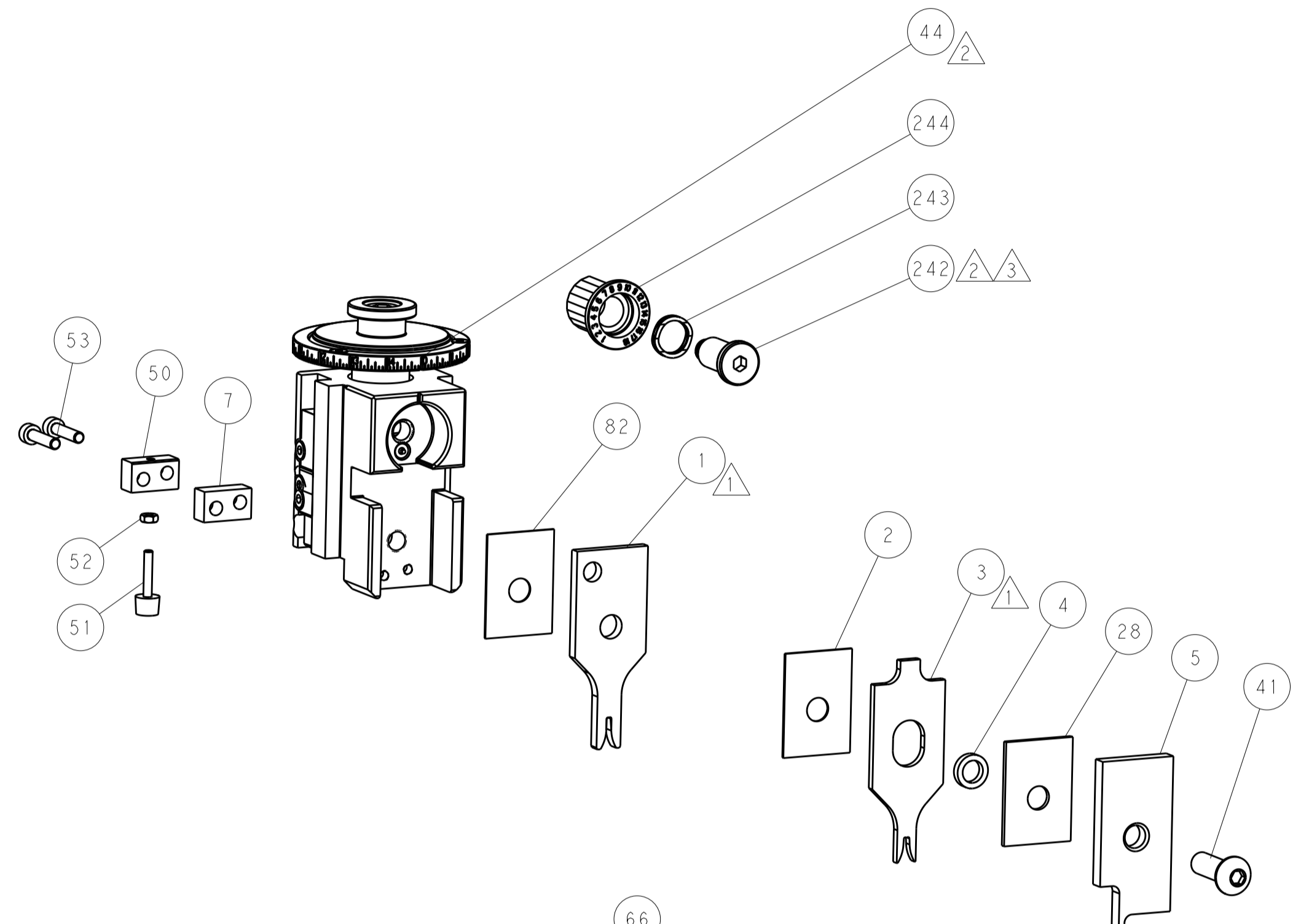
## PNEUMATIC



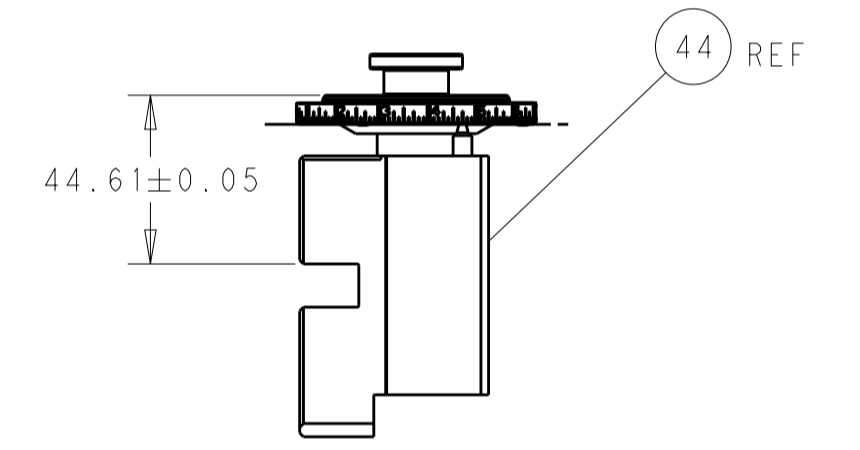
## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)



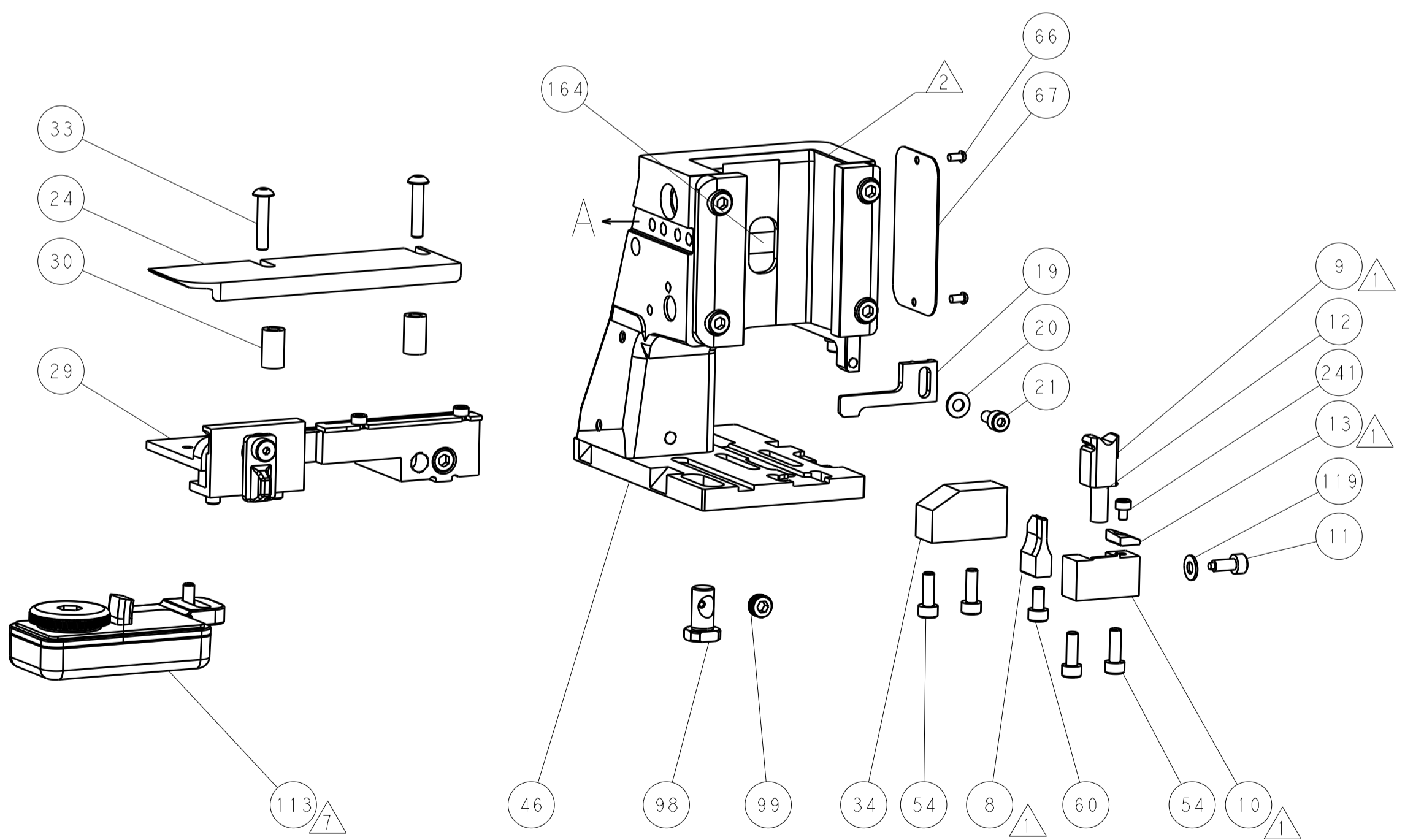
DETAIL A



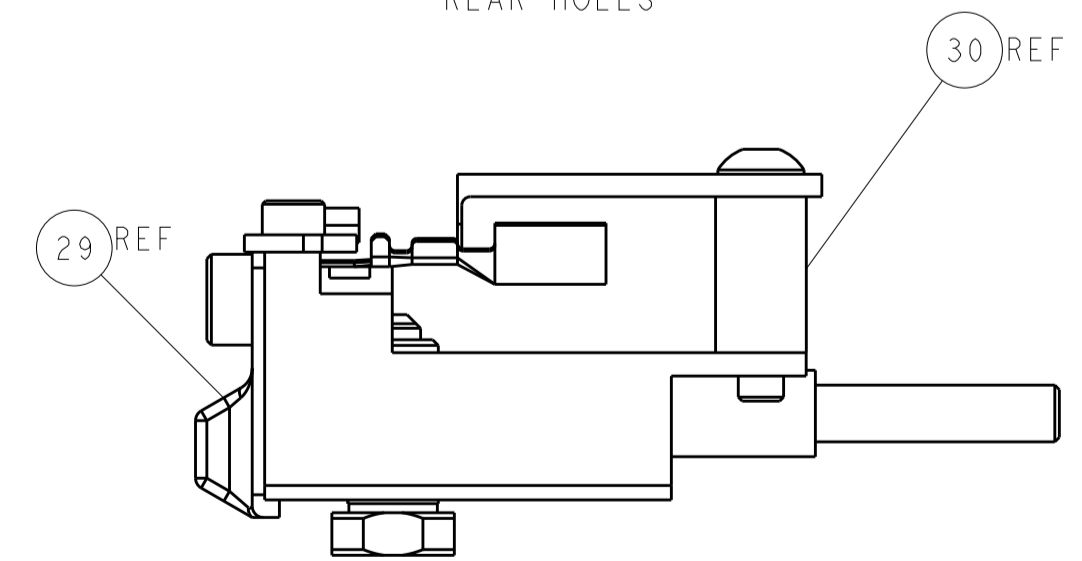
TERMINAL SUPPORT LOCATION



RAM SET-UP

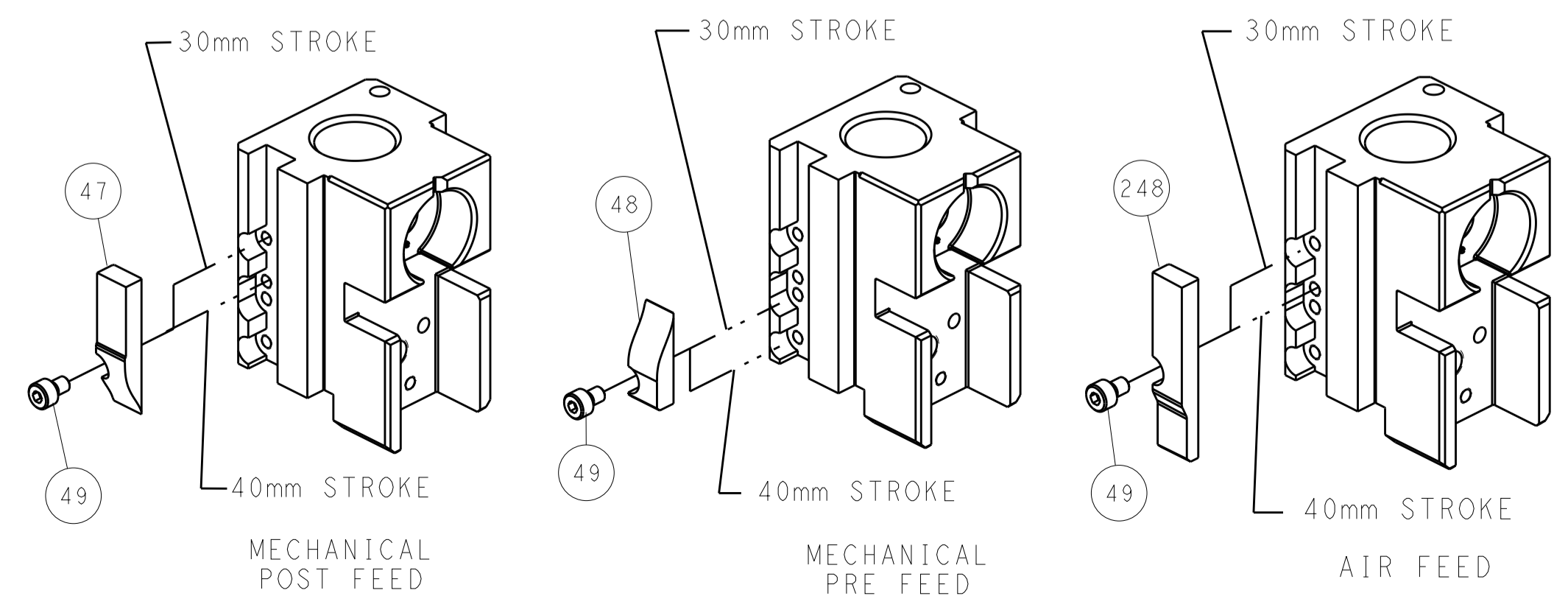


ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL

## CAM POSITIONS



**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN 31 JUL 2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK 31 JUL 2012		NAME Ocean Side Feed Applicator	
				S.XI 31 JUL 2012		SIZE CAGE CODE DRAWING NO	
				APVD 31 JUL 2012		A1 00779 ©=2151694	
				PRODUCT SPEC		RESTRICTED TO	
				APPLICATION SPEC		Customer Accessible Production Drawing	
				WEIGHT		SCALE 1:2 SHEET 2 OF 4 REV D	

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151694-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151694-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151694-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR  
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	F

APPLICATOR INSTRUCTIONS  
408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 2,5MM SYSTEM CONTACT SOCKET			
WIRE STRIP LENGTH 5.20-5.80 mm [1.205-.228 IN]		INSULATION DIAMETER RANGE Ø1.00-1.60 mm [.039-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18031-1		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928972-2	928972-3	928972-4	928972-5
928973-2	928973-3	928973-4	2-928973-2
2-928973-3	928974-2	928974-4	928974-5
928975-2	928975-3	928975-4	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	1.11+/-0.03 [1.04+/-0.001]	6.5
0.25mm2	1.07+/-0.03 [1.04+/-0.001]	7.1
0.20mm2	1.05+/-0.03 [1.04+/-0.001]	7.4

- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 5 INSULATION CRIMP HEIGHT SPECIFIED IN 114-18031-1 IS ONLY PERTINENT IF APPLICATION IS SPECIFIC FOR BMW. ALL OTHER APPLICATIONS SHOULD BE SET TO OPTIMUM INSULATION CRIMP HEIGHT RELATIVE TO INSULATION DIAMETER BEING USED.
- 6 CUT TO LENGTH AT ASSEMBLY.
- 7 TERMINAL LUBRICANT IS RECOMMENDED.
- 8. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
		P	LTN	DESCRIPTION	DATE	OWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

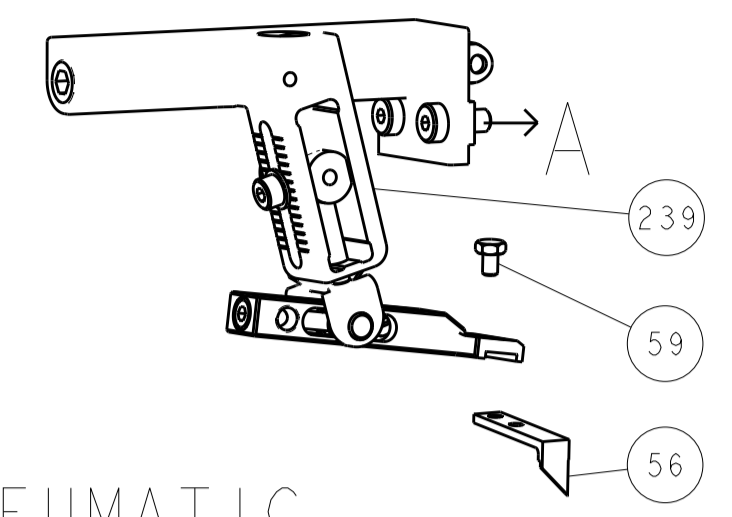
-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-4	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-4	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1-455888-5	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1-1333202-6	ANVIL, COMBINATION	8
-	1	1	6-240641-8	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	238011-9	BLOCK, CRIMPER SPACER	4
-	1	1	3-2119582-7	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-6	SPACER, CRIMPER	2
-	1	1	3-456403-7	CRIMPER, WIRE PREMIUM	1

PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

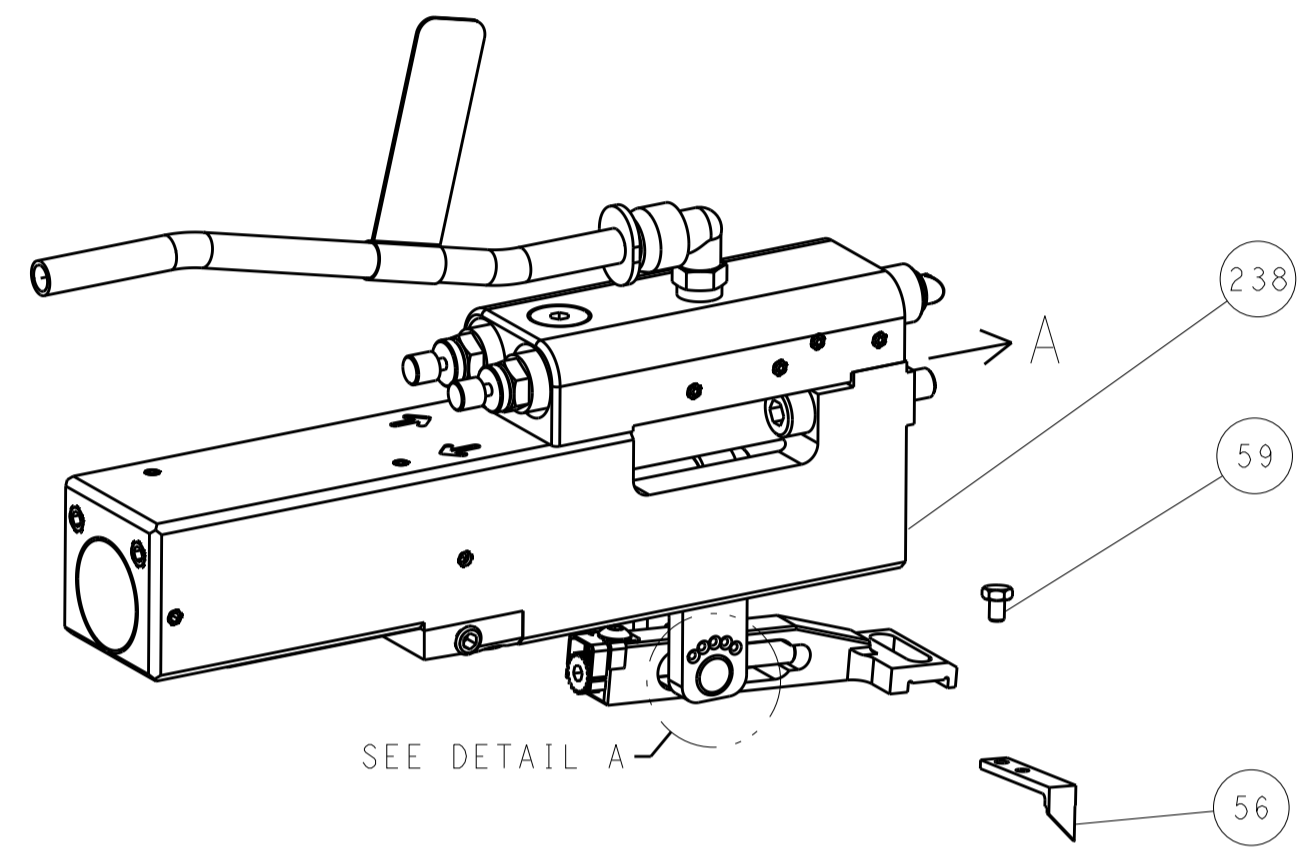
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN H. HUANG CHK S. XI APVD S. XI 31 JUL 2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	mm	±	PRODUCT SPEC	NAME Ocean Side Feed Applicator		
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-	-	-	1:2	A1	00779	2151694	-
Customer Accessible Production Drawing				SHEET 3 OF 4 REV D			

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

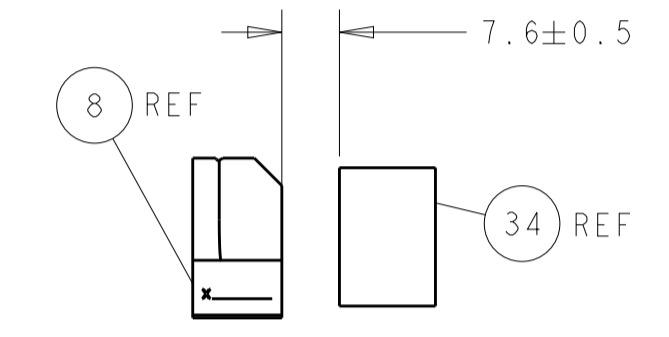
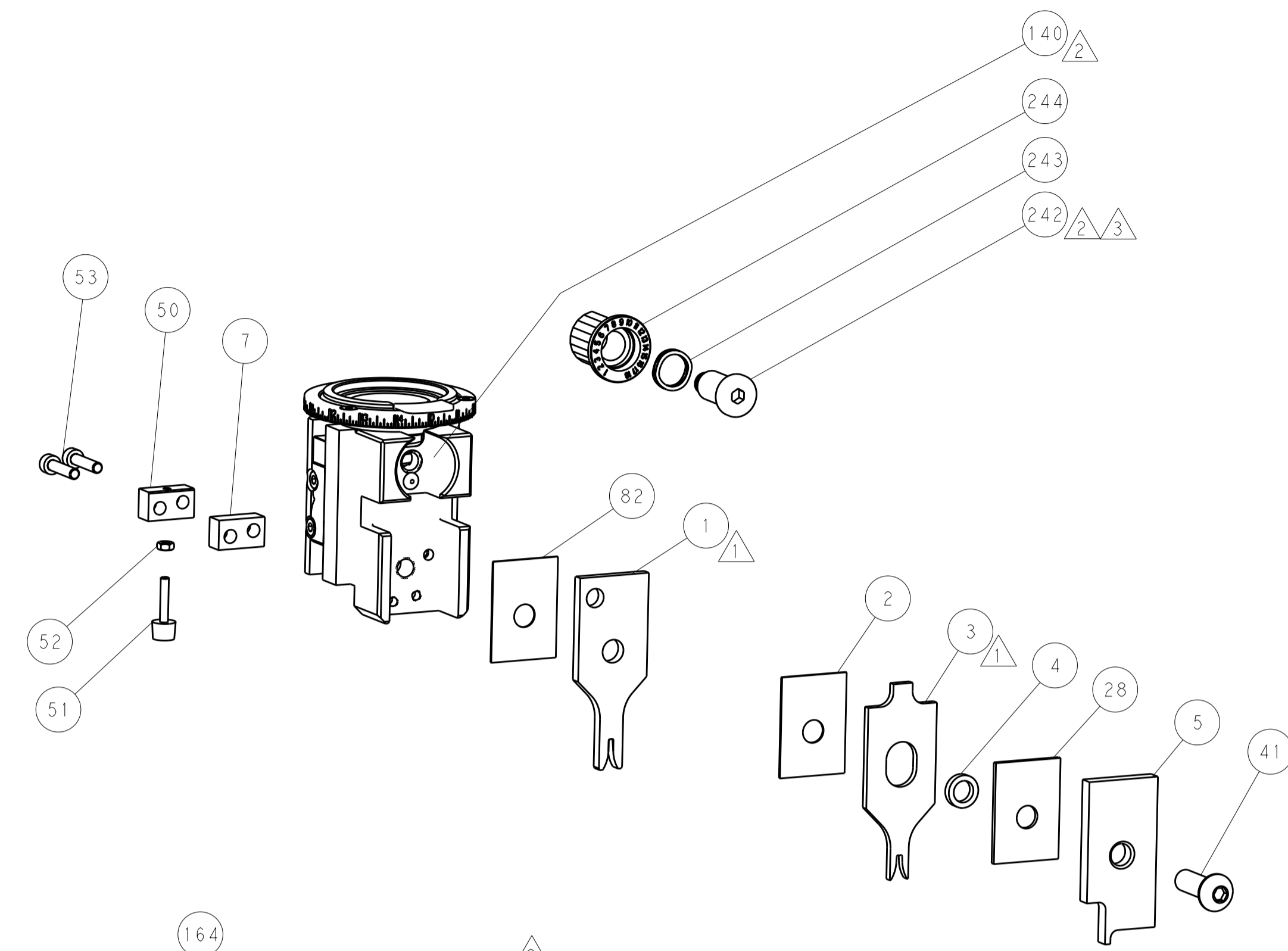
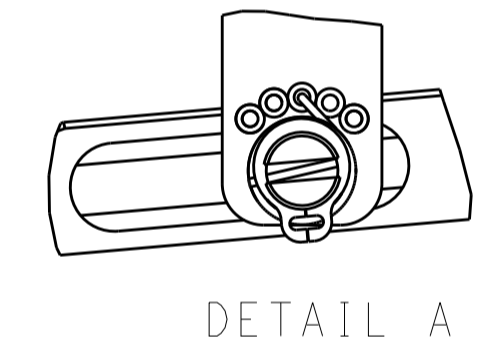
# FEED TYPE MECHANICAL



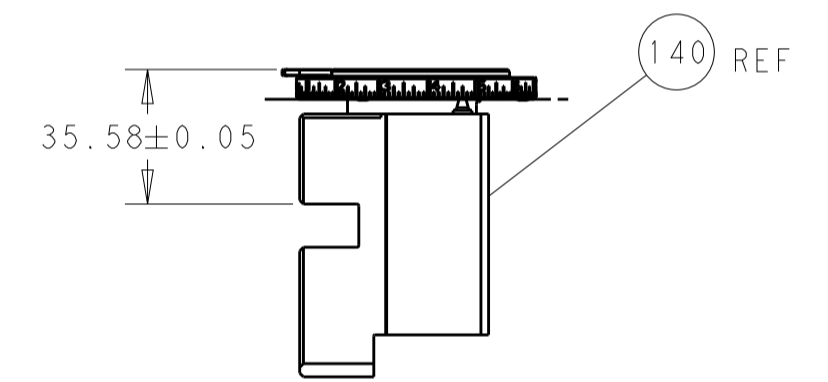
# PNEUMATIC



# FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

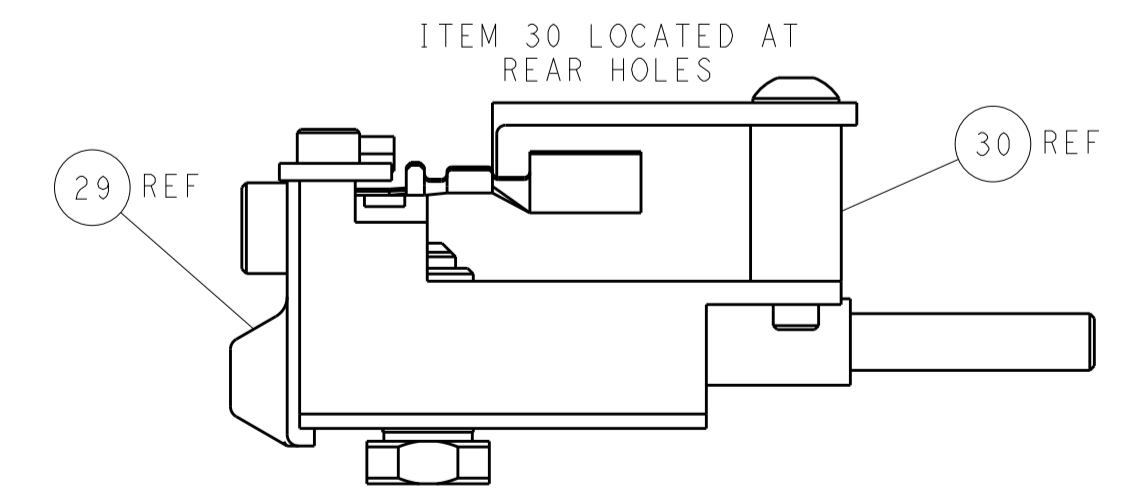
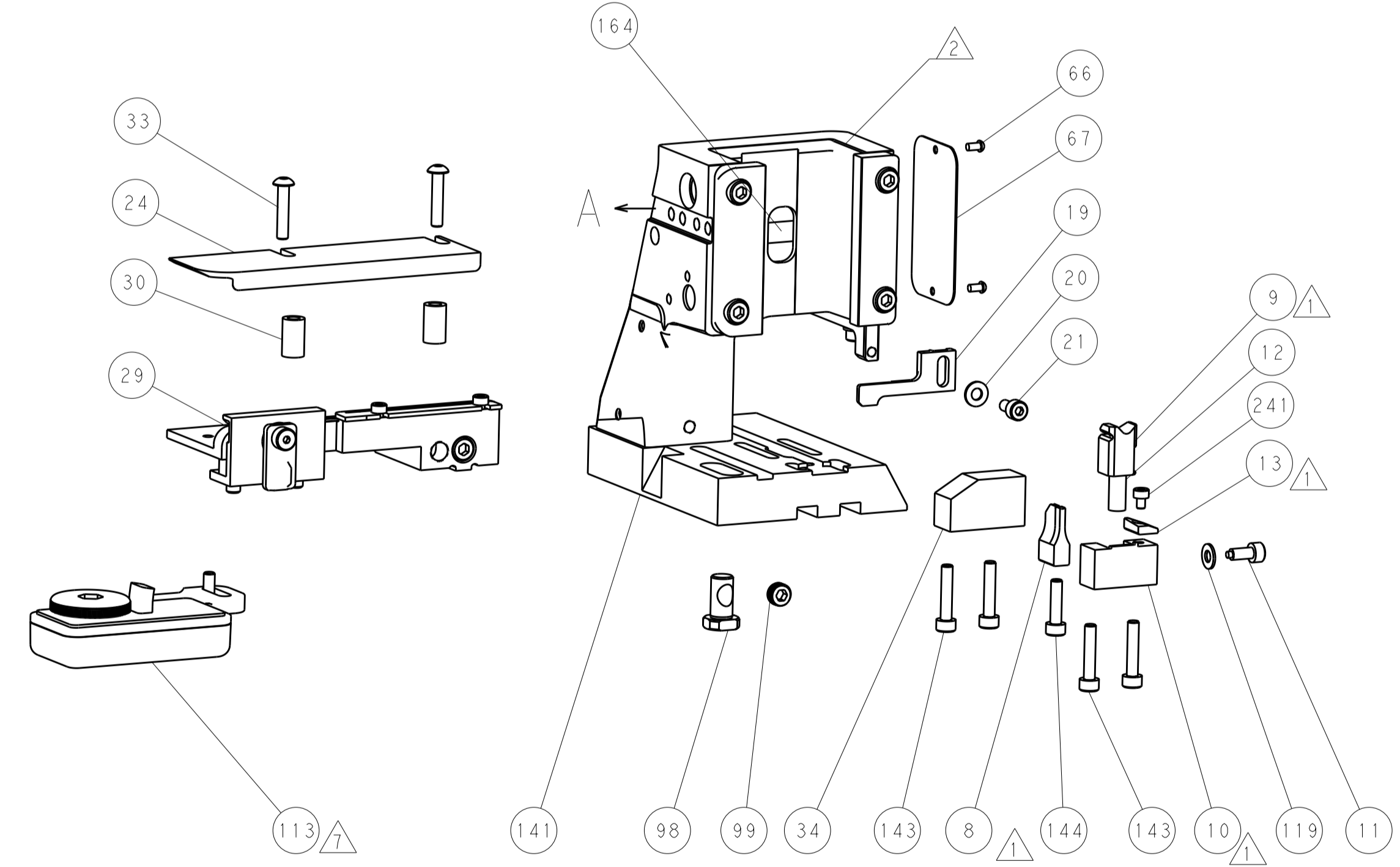
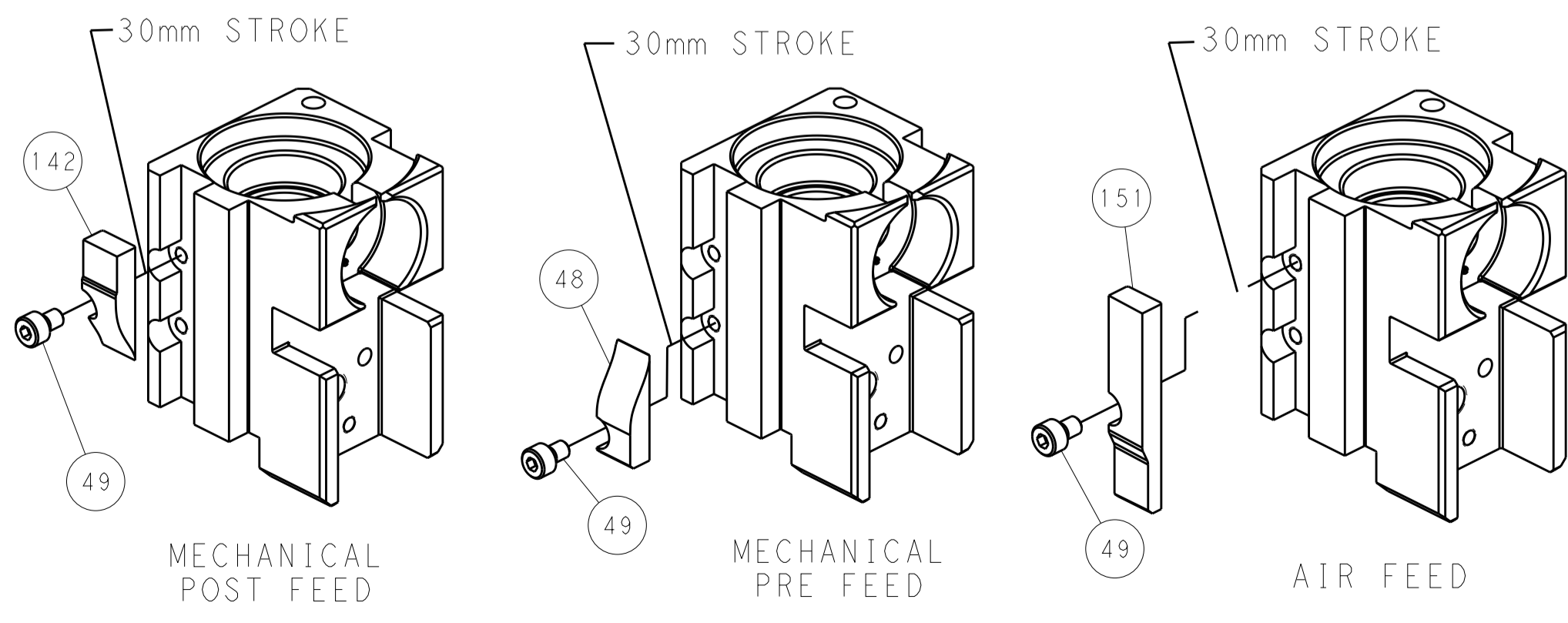


TERMINAL SUPPORT LOCATION



RAM SET-UP

# CAM POSITIONS



FEED TRACK POSITION GUIDE BY WIRE BARREL

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 31 JUL 2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC	±		CHK S. XI 31 JUL 2012	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S. XI 31 JUL 2012	SIZE	CAGE CODE	DRAWING NO
	2 PLC	±		PRODUCT SPEC	RESTRICTED TO		
	3 PLC	±		APPLICATION SPEC	SCALE	1:2	
	4 PLC	±		WEIGHT	A1 00779 ©=2151694		
	ANGLES	±		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SHEET	4	OF 4
MATERIAL	FINISH				REV	D	